

Work Order ID 133001

Thursday, May 21, 2015 3:49:25 PM

133001

Page 1

Item ID: 647.3917

Revision ID:

Item Name: Doubler

Start Date: 5/21/15

Required Date: 5/25/15

Reference:

Start Qty: 10.00

Req'd Qty: 10.00

10

10

N900040100

Cust Item ID:

Customer:

Setup Start

NS1

Stop

NS2

Approvals:

Process Plan: MCS

Date: 1505-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

647.3900

~~C (ECN)~~

C1

1505-22

110

0.00

110

Waterjet

FLOW CNC Waterjet

2024.090

Memo

1-Cut as per Dwg

Dwg Rev: C1

Prog Rev: C1

2-Deburr if necessary

0.00

10

Ø

Jm 15-5-23

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

10

Ø

Jm 15-5-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 133001

133001

Page 2

Thursday, May 21, 2015 3:49:25 PM

Item ID: 647.3917

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 5/21/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/25/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Station

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

(10)

MAY 25 2015

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O to ATG :

28649

1- Black Anodize as per Dwg 647.3900

2- PRIME AS PER DWG

Certification of Comformity is required

CZ

JUN 01 2015

10

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Packaging

10x SP 50640

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 133001

133001

Page 3

Thursday, May 21, 2015 3:49:25 PM

Item ID: 647.3917

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 5/21/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/25/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

BAS
38
9-89
JUN 24 2015

190

Identify as per dwg & Stock Location: mf

0.00

190

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

10
DAS
27
9-89

JUN 24 2015

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

ML5 JUN 24 2015

ML5 JUN 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																											
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld	☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Mislabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
																								☐ OTHER : _____																																							

Picklist Print

Thursday, May 21, 2015 3:49:30 PM

Work Order ID: 133001

133001

Parent Item: 647.3917

647.3917

Parent Item Name: Doubler

Start Date: 5/21/15

Required Date: 5/25/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.12.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.090

Purchased

No

sf

53.4000

1

M2024T3S 090

**

Jm15-5-23

2024-T3 .090 sheet

Location

Loc Qty

Loc Code

MAT021

53.4

123287

17.5

m130387

35.9

130387

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
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647.9317

R.250
4 PL

.625

.090

Ø.196
6 PL

0

.500

2.000

3.500

6.500

8.000

9.500

10.000

15-5-22
133004

ORIGINAL DATE
(UNLESS NOTED) 09-10-09
DRAWN BY: CHECKER:
DESIGNER: DRAFTER:
DESIGNED APPROVAL:
BY: SAUNDERS
DATE: 09-10-09
CONTRACT NO.:

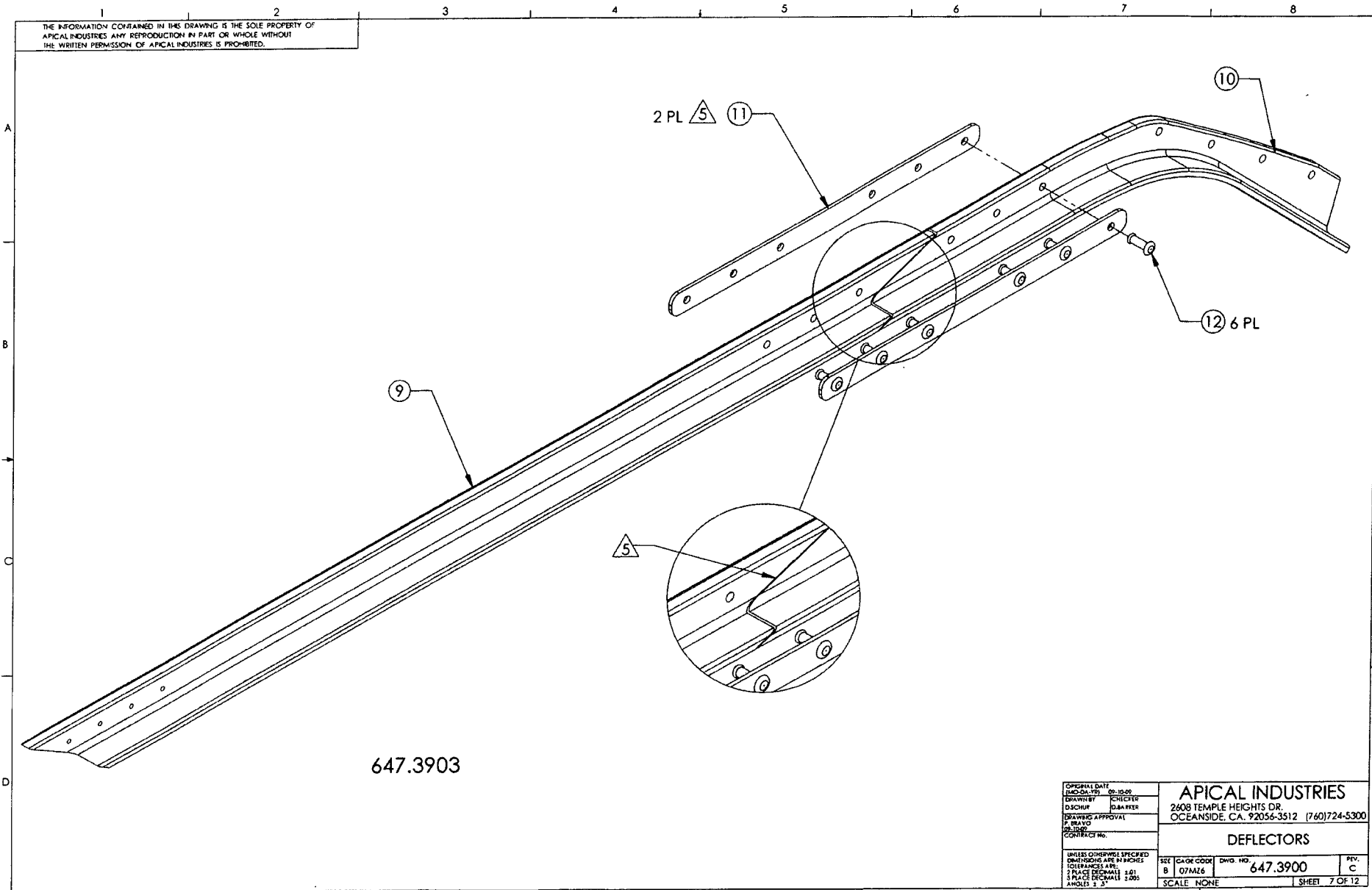
APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

DEFLECTORS

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

SER.	CAGE CODE	DWG. NO.	REV.
B	07MA26	647.3900	C
SCALE: NONE			SHEET 12 OF 12

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



ORIGINAL DATE (MM-DD-YY) 09-10-09	APICAL INDUSTRIES		
DRAWN BY DUSCHUP	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
DRAWING APPROVAL P. BRAVO	DEFLECTORS		
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 ANGLES ±.5°	SIZE	CAGE CODE	DWG. NO.
	B	07/MZ6	647.3900
	SCALE NONE		REV. C
		SHEET	7 OF 12

**9 FINISH: PRETREAT PR-148 ADHESION PROMOTER,
PRIME IAW MIL-P-23377J, TYPE I, CLASS N;
1-2 MIL MAX.**

04556

6			12	647.3072	RIVET	CR3213-6-9	
2			11	647.3917	DOUBLER		
1			10	647.3916	DEFLECTOR, UPPER HALF	△	△
1			9	647.3915	DEFLECTOR, LOWER HALF	△	△
1	1		8	647.3914	BREAKAWAY TIP LONG	△	△ △
		1	7	647.3913	BREAKAWAY TIP MEDIUM	△	△ △
1	1		6	647.3912	LOWER DEFLECTOR	△	△ △
			5	647.3911	212 UPPER DEFLECTOR	△	△ △
			4	647.3910	412 UPPER DEFLECTOR	△	△ △
A/R	A/R	A/R	3	601.2045	RTV, LOCITE 598		△
3	2	2	2	601.3074	RIVET	MS30470AD 6-12	
			1		DELETED		
X				647.3903	DEFLECTOR ASSY		△
X				647.3902	LOWER DEFLECTOR ASSY HIGH		
		X		647.3901	LOWER DEFLECTOR ASSY LOW		
.3903	.3902	.3901	FIND #	PART #	DESCRIPTION	MAT'L	SPEC
QTY			PARTS LIST				
NEXT ASSY (S)			ORIGINAL DATE: 09-10-07 DRAWN BY: J. BACHUR CHECKED: J. BACHUR DRAWING APPROVAL: 14 MAY 08 CONTRACT NO.				
647.3800			APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300				
			DEFLECTORS				
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°				
			REV. B	CAGE CODE 07A7M26	DWG. NO. 647.3900	REV. C	
			SCALE NONE				SHEET 1 OF 12

[illegible]

DART AEROPACE LTD	Work Order:	133001
Description: DOUBLER	Part Number:	647.9317
Inspection Date: 6/79300 Rev: C1		Page 1 of 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28649**

Purchase Order Date 6/1/2015

PO Print Date 6/3/2015

Page Number 3 of 4

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

6	132763	647.1711 PLATE REV.C	6/8/2015	6.00	\$30.25	\$181.50
			Yes			
			6/8/2015			

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$181.50

7	133001	647.3917 DOUBLER REV.C	6/8/2015	10.00	\$6.60	\$66.00
			Yes			
			6/8/2015			

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$66.00

SP15-0610

Note:

6/3/2015



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63752

Date: 10-Jun-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
4 ea	Part: 646.3311 RH HALF HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150438	Rev: N/C PO: PO28649	Line:
6 ea	Part: 646.3812 GUSSET BRACKET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150439	Rev: PO: PO28649	Line:
6 ea	Part: 647.1710 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER Job: 20150440	Rev: PO: PO28649	Line:
6 ea	Part: 647.1711 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER Job: 20150441	Rev: PO: PO28649	Line:
10 ea	Part: 647.3917 DOUBLER HARD ANODIZE MIL-A-8625 TY III CL 2	Rev: C PO: PO28649	Line:



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63752

Date: 10-Jun-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	PRIME MIL-P-23377J TYPE I CLASS N		
	PRIMER SUPPLY CUSTOMER		
	Job: 20150442	PO: PO28649	Line:
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>10/6/15</u> CERTIFIED SIGNATURE : <u>[Signature]</u> RECEIVER SIGNATURE : <u>SP 15-06-10</u>			